

Date: Friday, 01/05/2009 11:20:12 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LEFT ARM WELDMENT
Job Number :	47654		
Estimate Number :	12080		
P.O. Number :		Part Number :	D33543
This Issue :	01/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3354 REV C
First Issue :	1/1	Project Number :	N/A
Previous Run :	42763	Drawing Revision :	C
Written By :		Material :	
Checked & Approved By :	<u>JUD 09.05.07</u>	Due Date :	20/05/2009
Comment :	est rev A 06.01.23 new issue EC Est Rev:B 07-12-10 rev C dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NR1250	4130N ROUND BAR 1.250
-----	-------------	-----------------------



Comment: Qty.: 0.6300 f(s)/Unit Total : 2.5200 f(s)

AISI 4130 ROUND BAR 1.250" dia. batch:

M110740 (x 1.2')
M109744 (x 1.2')

09.05.07

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA623 & DWG D3354

FOLIO REV: 6

DWG REV: 6

2-DEBURR AS REQUIRED

09.05.07

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09.05.07

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1-Drill cotter pin hole as per dwg D3354

2-Deburr

09.05.07 (4)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

09/05/08 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/05/2009 11:20:13 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEFT ARM WELDMENT

Job Number: 47654

Part Number: D33543

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



(92)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Carl*

9/5/8

SD

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <i>U 7654</i>
Description: Wheel Shaft		Part Number: D3354-3
Inspection Dwg: D3354 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

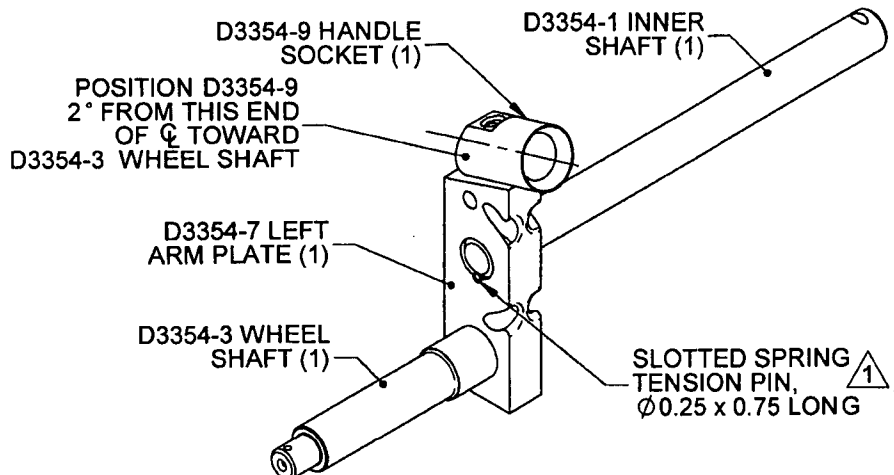
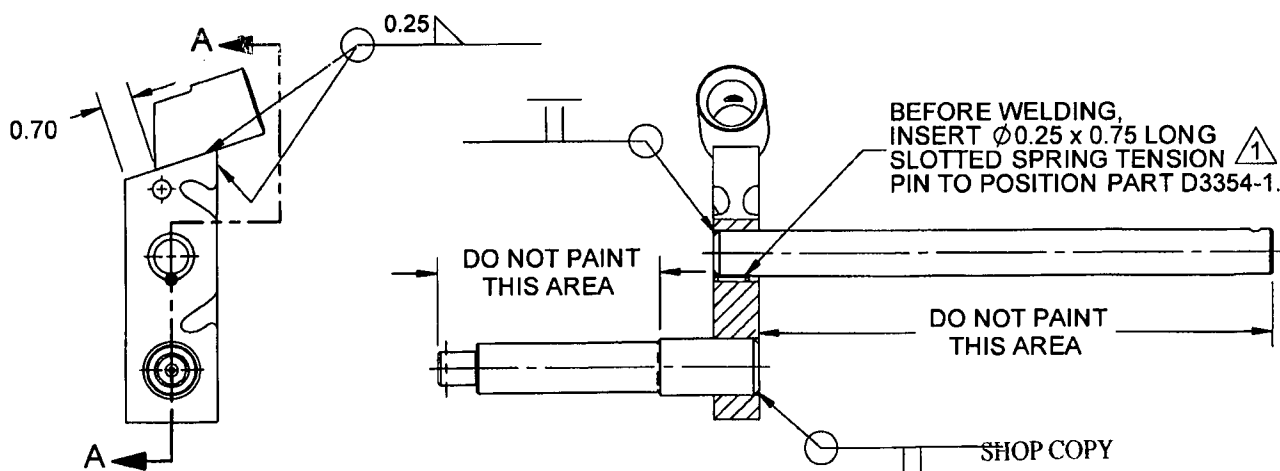
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.04	+/-0.030	<i>7.04</i>	<i>/</i>			
4.020	+0.010/-0.000	<i>4.024</i>	<i>/</i>			
0.85	+/-0.030	<i>.855</i>	<i>/</i>			
0.06	+/-0.030	<i>.06</i>	<i>/</i>			
0.13	+/-0.030	<i>.12</i>	<i>/</i>			
Ø1.250	+0.001/-0.004	<i>1.247</i>	<i>/</i>			
Ø1.103	+0.001/-0.002	<i>1.1025</i>	<i>/</i>			
0.750 Thread	+/-0.010	<i>.745</i>	<i>/</i>			
0.03 x 45°	+/-0.030 x 0.5°	<i>.03 x 45°</i>	<i>/</i>			
Ø0.152	+0.005/-0.001	<i>.153</i>	<i>/</i>			
R0.02	+/-0.030	<i>R.015</i>	<i>/</i>			
R0.050	+/-0.010	<i>R.050</i>	<i>/</i>			
0.660	+/-0.010	<i>.660</i>	<i>/</i>			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: <i>09.05.07</i>	Date: <i>09/05/08</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.04.20	Ø0.152 dimension removed	KJ/JLM	
C	08.01.16	Dwg Rev updated	KJ/EC/DD <i>[Signature]</i>	<i>[Signature]</i>

DART**RELEASED**
07/12/06

DESIGN <i>RF</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>lb</i>	APPROVED <i>MP</i>	DRAWING NO. LEFT ARM WELDMENT	REV. C SHEET 1 OF 7
DATE 07.12.06		TITLE D3354	SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	
C	07.12.06	CHANGE TOLERANCE ON D3354-7 LEFT ARM PLATE HOLE FOR D3354-3 WHEEL SHAFT	

**D3354-042 MIRROR
ARM WELDMENT****D3354-041 LEFT ARM WELDMENT**

SHOP COPY
RETURN TO
ENGINEERING
SECTION A-A
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *47654*

NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

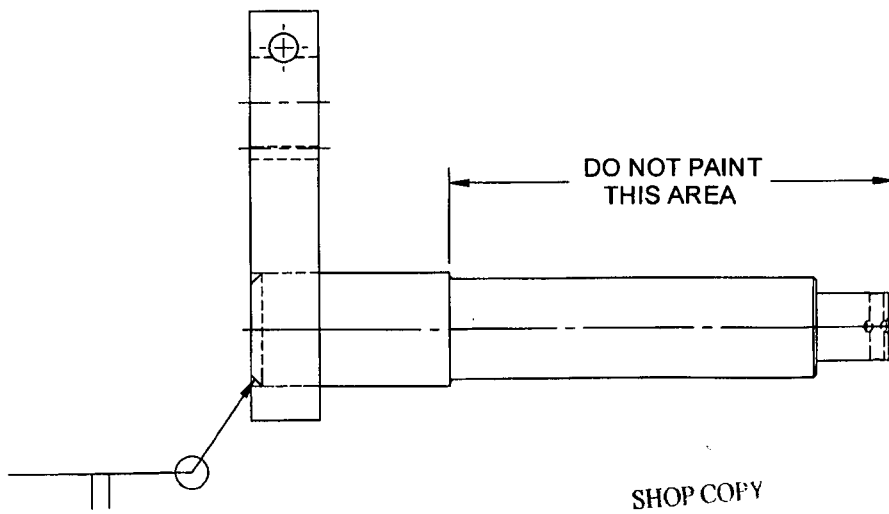
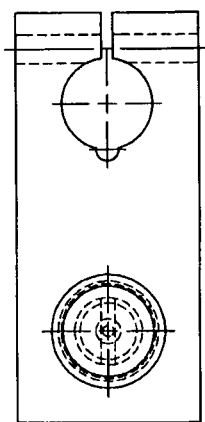
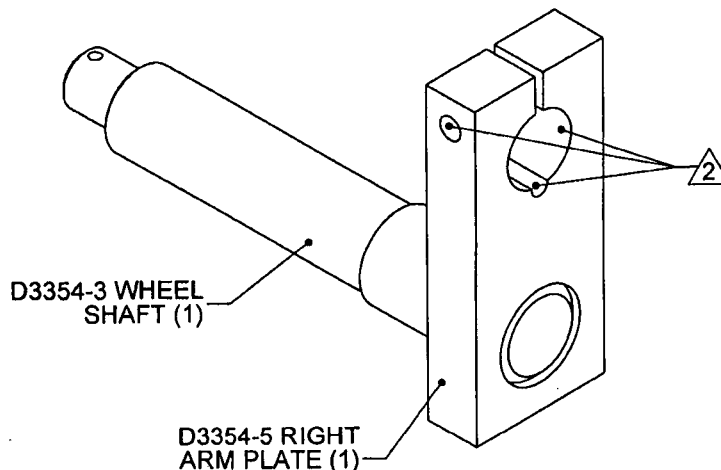
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DESIGN <i>RH</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LJ</i>	APPROVED <i>WP</i>	DRAWING NO. D3354	REV. C SHEET 2 OF 7
DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED
07/12/07 *WJ*



D3354-043 RIGHT ARM WELDMENT

NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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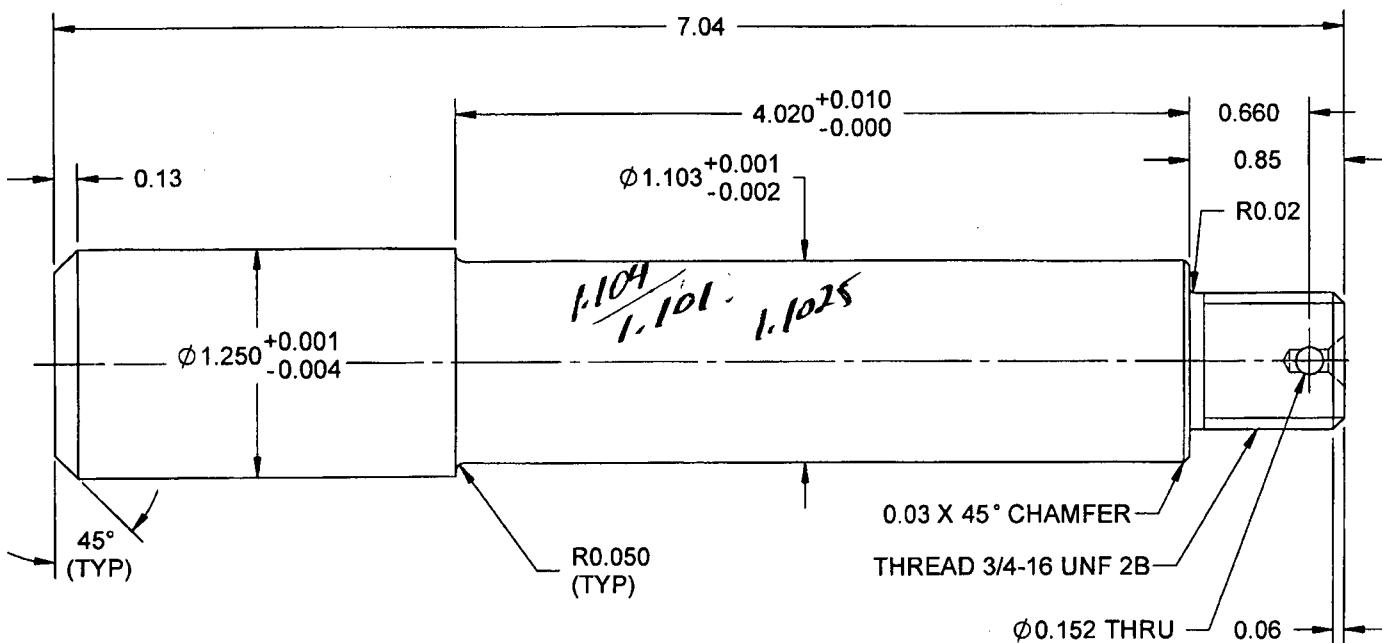
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DESIGN <i>[Signature]</i>	DRAWN BY <i>JC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3354	REV. C SHEET 4 OF 7
DATE 07.12.06		TITLE LEFT ARM WELDMENT SCALE 1:1	

RELEASED
07.12.07 *[Signature]*



D3354-3 WHEEL SHAFT

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WITHOUT NOTICE
WORK ORDER
NO. *471654*

NOTES:

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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